

Job Traveler

Job Number: 231347-01



Due Date: 09/12/2023

Sold FLOW-ZONE, LLC
To: 3504 DWAYNE ROAD
ROSHARON, TX 77583

Ship FLOW-ZONE - ROSHARON
To: 3504 DWAYNE RD
Rosharon, TX 77583
United States

Order No: 231347

Dated: 07/18/2023

Quote No: 19835

Customer: FLOW-Z134580

PO Num: 9299274

Ship Via:

Priority: 3 - STANDARD

Part Number: *3TE3626Y

Product Code: TEE

Description: TE 36X26 .625 X .500-
WPHY60

Master Job No:

MSSSP75-19

Total Qty Open: 4 EA

Qty Posted: 0 EA

Qty To Make: 4

Start Date: 07/26/2023

Phone:

Contact: JUAN MALAVE

Fax:

Job Notes

BCLK
B10623
PIPE SHOP TRAVELER 241-2023
FULL PLATE ALLOCATED; DO NOT ADD SCRAP
QR CODE

Routing

Routed By:

Quantity 4

Step No	Work Cntr / Vendor	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
<u>Dept</u>	<u>Operation</u>	<u>Time</u>	<u>Time</u>	<u>Time</u>	<u>Per Hour</u>	<u>Start</u>	<u>End</u>	<u>Quantity</u>
10	PIPE 3 PLATE BURN					07/26/2023	07/26/2023	4
20	PIPE 6 FURNACE HEAT					08/01/2023	08/01/2023	4
30	PIPE 4 BIG ROLL					08/01/2023	08/01/2023	4

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Report Generated: 07/18/2023 10:15:58 AM

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40	PIPE 7 STRING UP	Initial Weld String-up	08/01/2023 08/01/2023	4
				
50	PIPE 8 ID WELD # 1	ID Weld # 1 ID Weld	08/01/2023 08/01/2023	4
				
60	PIPE 12 PIPE GOUGE	Pipe Gouge Pipe gouge	08/01/2023 08/01/2023	4
				
70	PIPE 5 WELD PREP	Grind After Gouge Weld prep	08/02/2023 08/02/2023	4
				
80	PIPE 9 OD WELD	OD Weld OD Weld	08/07/2023 08/07/2023	4
				
90	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut	08/15/2023 08/15/2023	4
				
100	FORGE 8 TRIM	Torch Cut Cut hole	09/18/2023 09/18/2023	4
				
110	FORGE 12 FORM/PRESS	2000 Ton Press Forming	09/18/2023 09/18/2023	4
				
120	FORGE 8 TRIM	Torch Cut Trim	09/19/2023 09/19/2023	4
				

130	FORGE 7 HEAT TREAT	Heat Treat Heat treat	02/13/2024	02/14/2024	4
					
140	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	02/14/2024	02/14/2024	4
					
150	PIPE 13 X RAY	Pipe X Ray X-ray	02/14/2024	02/15/2024	4
					
160	E1 MACHINING	E1 Extender Expander	02/15/2024	02/15/2024	4
					
170	M1 MACHINING	M1 Big Mill Machining	02/15/2024	02/20/2024	4
					
180	STAMP 1 STAMP	Stamping	02/20/2024	02/20/2024	4
					
190	INSPECT 1 INSPECTION	Inspection 1	02/20/2024	02/20/2024	4
					
200	SHIPPING SHIPPING	Shipping	02/20/2024	02/20/2024	4
					
Time per Piece (HR):		0.00	0.00	0.00	0.00
Total Time for Job (HR):		0.00	0.00	0.00	

Materials List

Quantity					Quantity: 4	
Needed	On Hand	Posted	Short	Unit	Description	Sub-Assy Vendor
8,640.00000	497,304.00000	8,640.00000	0.00000	LB	0PL1633	NO CLEVELAND-CL
					PL0 1-A633-E	
					Quantities from Bins/Lot Number:	
					BCLK-07,08,09 (8640.0)	

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCLK
36X26
.625X.500
WPHY60
231347-01

Pipe Shop Traveler Tee Cyl.

241-2023

7/18/2023

☐ Pipe Shop Copy
☐ Pipe Shop Original

Customer	FLOWZONE		SFI Order No	231347-01	Due Date	8/12/2023
Part	42.000	OD X	1.000 X	112.000	Ship Date	9/12/2023
Plate Size	1.000	X	128.806 X	112.000	NoPcs	2
Heat No.	R1852				Code	BCLK-08
Material	A633E	Test Material			Test No	

Cut 2 Plate(s) 1.000 X Thick X 128.806 Width X 112.000 Length 4091 Lbs.

Per Sketch #

From (1) Plate(s) 1.000 Thick X 112.000 Wide X 272.000 Long

Stamp Plates With Heat Code BCLK-08

Scarf to 128.806 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " O.D.

Tack Weld Using 5/32 " Dia. E9018M Electrodes Per Procedure # SMAW-HSLA-132-REV. 1

Use Weld Procedure SAW-HSLA-101-REV. 11

Weld I.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Backgouge to Sound Metal and Condition Grind O.D. Weld Groove

Weld O.D. Using 3/16 " Dia. LINCOLN LA-85 Wire and LINCOLN 888 Flux.

Hot Reroll to Roundup

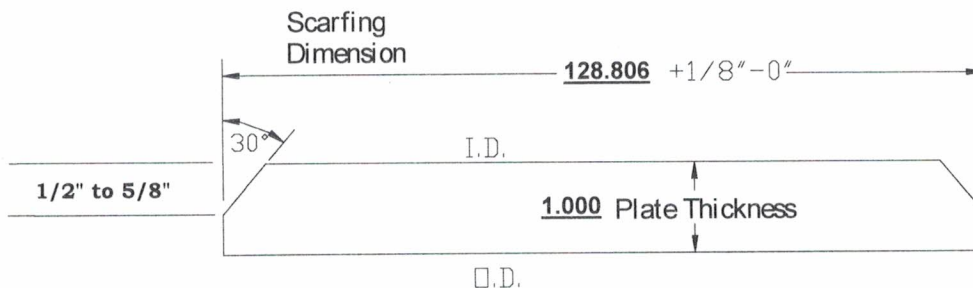
Torch Cut Into 2 Pcs @ 55 Inches

Paint Mark on Cylinder FLOWZONE 231347-01

Stamp Each Cylinder in (2) Places With Heat Code BCLK-08

Fitting Description: (4)TE 36X26 Y60

Comments:



36" Run Diameter = 36.542"
 Outlet Diameter =

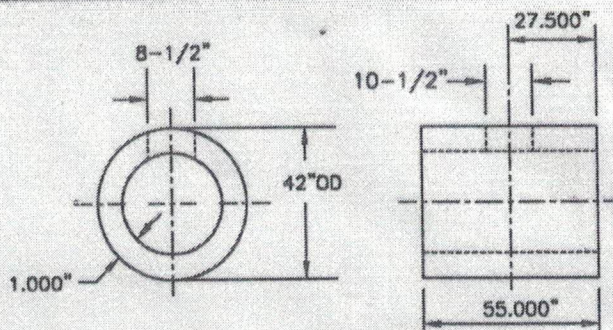
PREFORM (Oper. 1&2) in 36x24" dies.
 FINAL FORM (Oper. 3) in 36x30" dies.

Material Size 42" O.D. x 1.000"W
 Length 55.000"

Ovaling Data:
 Oval HOT to: 35-3/4" ± 1/4"

Hole size 8-1/2" x 10-1/2" oval

Grind 1/8" radius on hole edges I.D. and O.D.

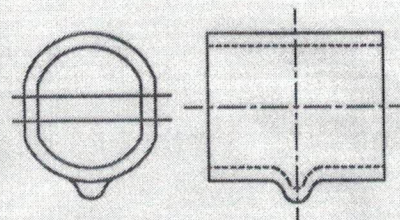


Preform Data: (1st and 2nd operations to be formed in 36x24" dies):

Press: Machine 2000 Ton Set up #10139 Upper Die # 50046
 Lower Die # 50082 with 36x24" Insert #50082

1st Oper: Heat to 1650°F.—Quench in 28 inches of water.
 Close dies to 5-1/2" and
 Pull 13-3/4" diameter plug (4" rod).

2nd Oper: Re-heat to 1650°F.
 Quench in 23-1/2 inches of water
 Close dies to 1" and
 Pull 20.000" diameter plug (4" rod).

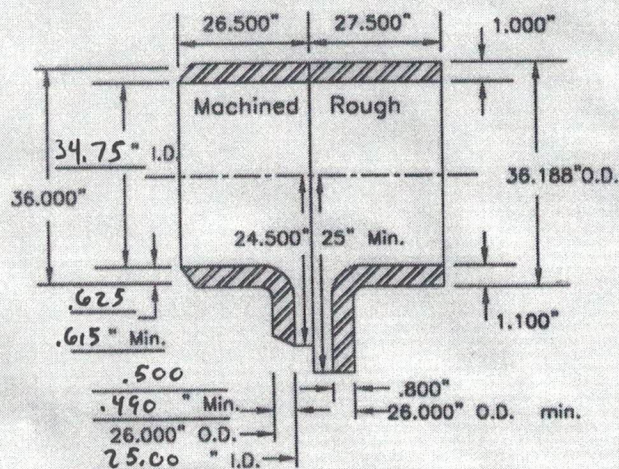


3rd Operation:

FORM in 36x30" Dies.
 Set-up :10139
 Upper Die :50046
 Lower Die :50092 (36x30)

3th Oper: Re-heat to 1650°F.
 Do not quench
 Close dies hot and
 Pull 24-1/2" plug (4" pull rod).

SHOP NOTE: Outlet will require end sizing.



			DATE: 11-23-99
			SCALE: NONE
			DRAWN BY: J.D.
			CHECKED BY: Bull
REV	DESCRIPTION	BY	DATE

36" x 26"
 .625 x .500
 HIGH YIELD
 TEE MFG. DATA

DWG#
 36-26-1
 Use for bevel thicknesses:
 36" Run—.666" and less.
 26" Outlet—.562" and less.

FORM BY EXTRUSION PER CARD: _____

PRE CUT ENDS

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT

HEAT TREATMENT PER QCP 8.1 REV.1: (WITH TEST MAT'L B- _____)

HEAT TREAT 1/2 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 HR @ 1200 °F - AIR COOL - FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION) _____

MACHINE PER MSS-SP75-14

0.625

BORE RUN I.D. STRAIGHT TO: 34.000 + 1/4 -0 34.750

0.615

0.500

BORE OUTLET I.D. STRAIGHT TO: 24.250 + 1/4 -0 25.000

0.490

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE